

Work Order ID 110173

110173

Page 1

December-17-13 9:17:28 AM

Item ID: D350-748-101

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-748-141	G
--------------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG003

DAS
31
9-89

14-03-18

105

QC15- Crosstube Dimensional Check

0.00

105

QC

Memo

0.00

Quality Control

VERIFY WITH VENDER FOR OVEN TIME AVAILABILITY

N/A
TW

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Item ID: D350-748-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Crosstube

Stop ***NS2***

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

BENDING MACHINE - CROSSTUBES

0.00

CNC Bend 1

Memo

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT _____

****UNDER BEND .225" PER SIDE****

****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****

*tw**14-02-03*

120

0.00

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

Quality Control

****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****

SNP
*14/2/20**1*

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Item ID: D350-748-101

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

0.00

125

Outsource1

Memo

0.00

Outsource process - Heat Treat

ISSUE P/O TO METCOR: 22878

Stress relief

Heat treat crosstube as per QSI010 4.3 within 12h after bending

CL 14/02/04 (1)

126

Receive & Inspect for Damage & Mat'l Certs

0.00

126

Packaging

Memo

0.00

Packaging

14/2/6 (1)

127

QC15- Crosstube Dimensional Check

0.00

127

QC

Memo

0.00

Quality Control

MARK CUT LINES

DP 14-2-13

03
2

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Item ID: D350-748-101

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

128

0.00

128

Crosstubes

Memo

0.00

CUT TUBE AT HEIGHT ON FAI SHEET

VERF HEIGHT 23.125 (A)
23.18 (B) BY QC 15 LEVEL INSPECTORVERF TWIST 0.029 BY QC15 LEVEL INSPECTOR

130

0.00

130

Crosstubes

Crosstubes

Memo

0.00

2- Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs
Set-up drill table as per QSI 010

3- Deburr

4- Engrave Part # and Batch # as per Dwg D350-748-141

5- Remove all marks from tube within limits of D350-748-141

6- Apply a light coat of LPS3 on the interior of tube

Batch: _____

MO/25 14/02/18

TW 14-02-19

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Item ID: D350-748-101

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

150

Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 23080
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

C2 14/02/20 @R 12/3/11 @

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Item ID: D350-748-101

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Crosstube

Stop

NS2

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

174

Outsource process - NDT per QSI038 4.1

0.00

174

Outsource2

Memo

0.00

Outsource process - NDT

ISSUE P/O TO ACUREN:

P023357

P14-03-17

176

Receive & Inspect for Damage & Mat'l Certs

0.00

176

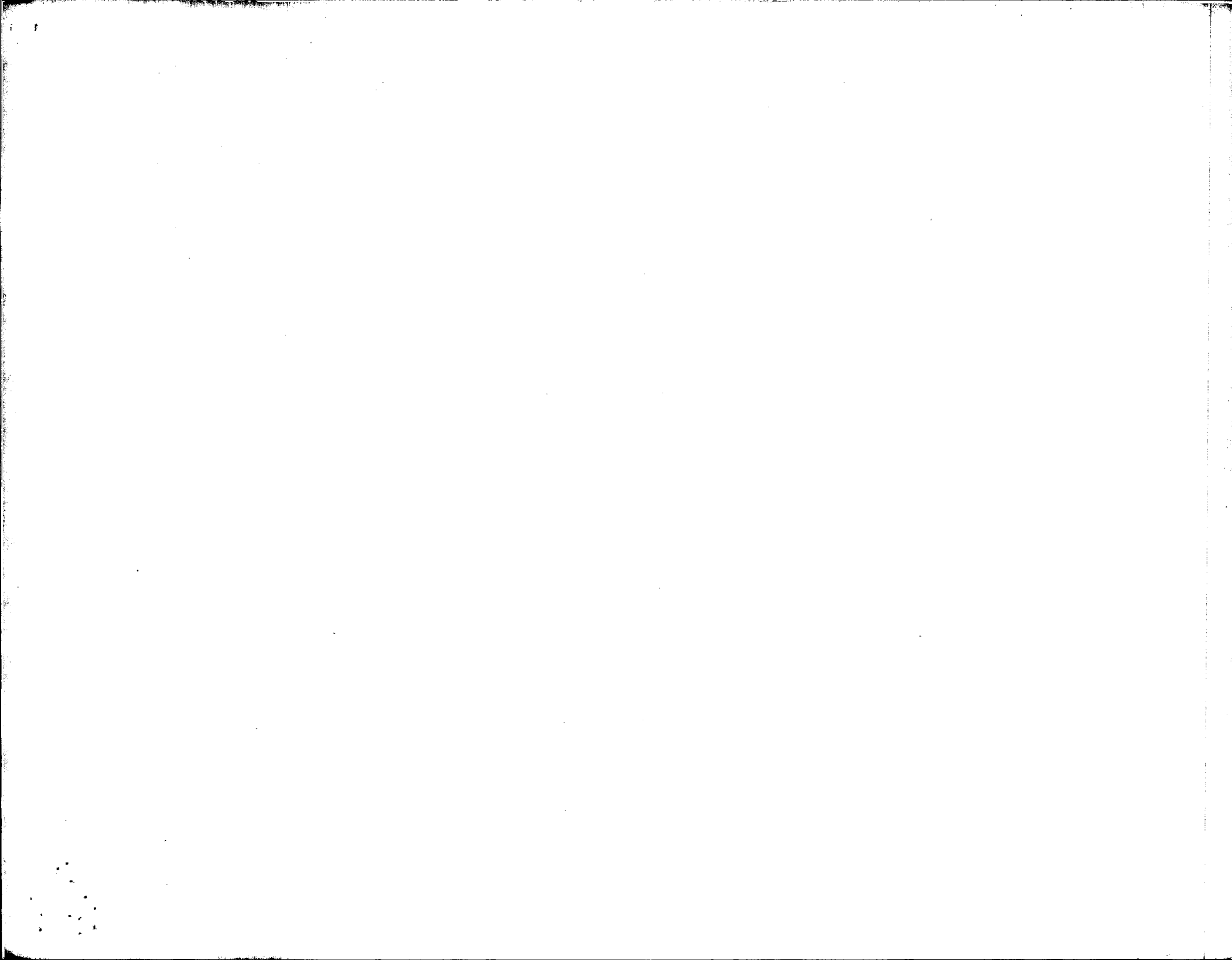
Packaging

Memo

0.00

Packaging

P14/3/13 (4)



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Item ID: D350-748-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Crosstube

Stop

NS2

Start Date: 12/17/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

178

QC5- Inspect part completeness to step on W/O

0.00

178

QC

Memo

0.00

Quality Control

180

SprayPaint

0.00

180

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside crosstube as per QSI 005 4.2

BATCH: 126873 T: 8:15-9:00

2-Prime Outside of Tube as per Dart QSI 005 4.2

BATCH: 128330 T: 1:00-2:00

190

QC14- Inspect Spray Paint

0.00

190

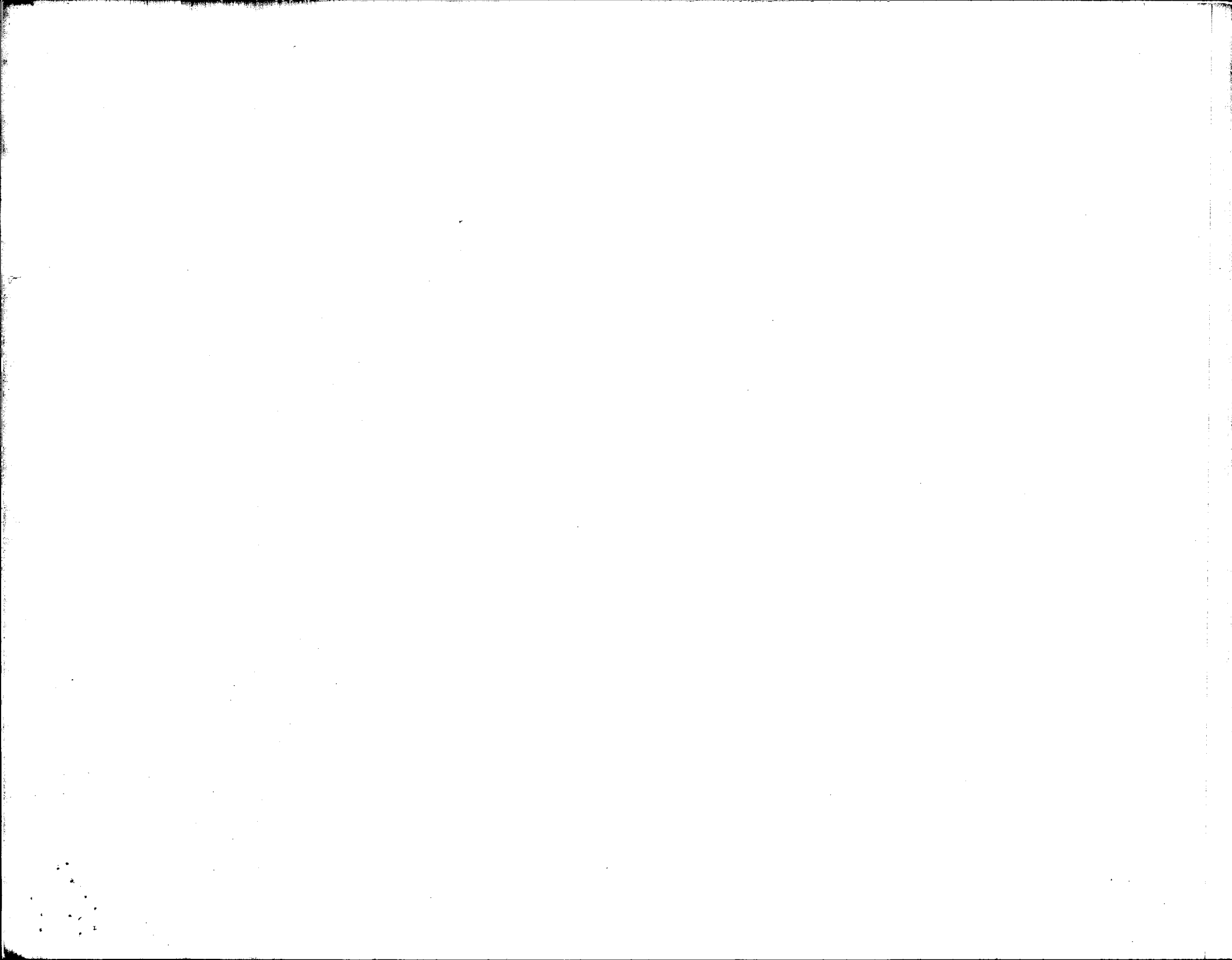
QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches



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Item ID: D350-748-101

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

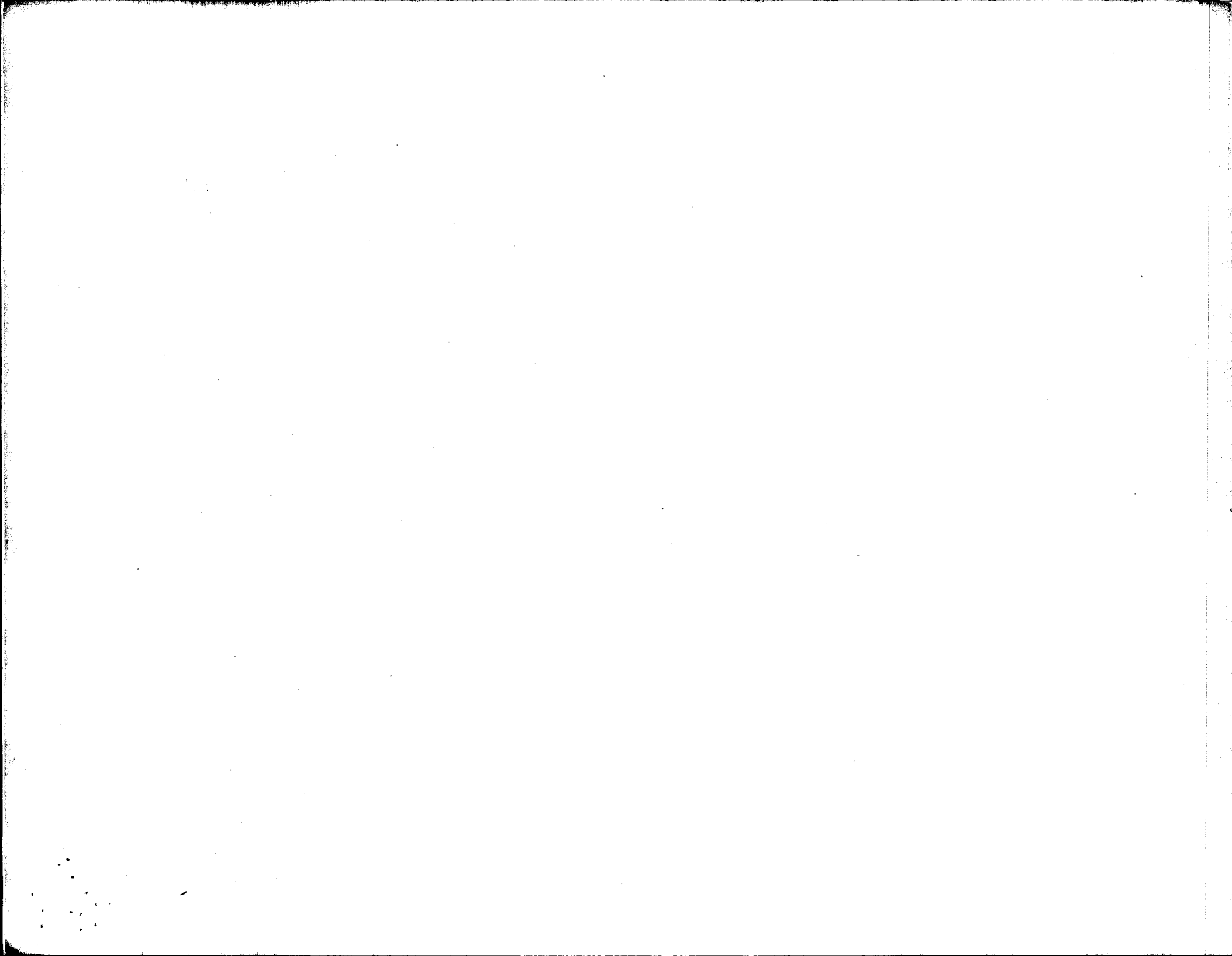
Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Crosstubes	0.00							
200									
Crosstubes	Memo	0.00							
Crosstubes	INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER								
	1-Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg								
	2-Install supports with Proseal 890 per D350-748-141 and QSI 015								
	A/R Proseal 890 Batch: <u>127663</u>								
	EXP: <u>4/14</u>								
	3-Install supports clamps Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS.								
	PROSEAL CURE TIME 72 HOURS:								
	Start: <u>2:15</u>								
	Finish: <u>2:45</u>								
	RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.								

1 0 0 AS
14-3-14



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Item ID: D350-748-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Crosstube

Stop ***NS2***

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.00

DAS

16

9-89

14/03/17

Quality Control

***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED
FOR 72HOURS AS PER DWG.***

220

Pick Kit

0.00

220

Packaging

Memo

0.00

DAS

32

9-89

14/3/17

Packaging

230

QC4- 100% Inspect kits for completeness

0.00

230

QC

Memo

0.00

DAS

31

9-89

14-03-18

Quality Control

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Item ID: D350-748-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

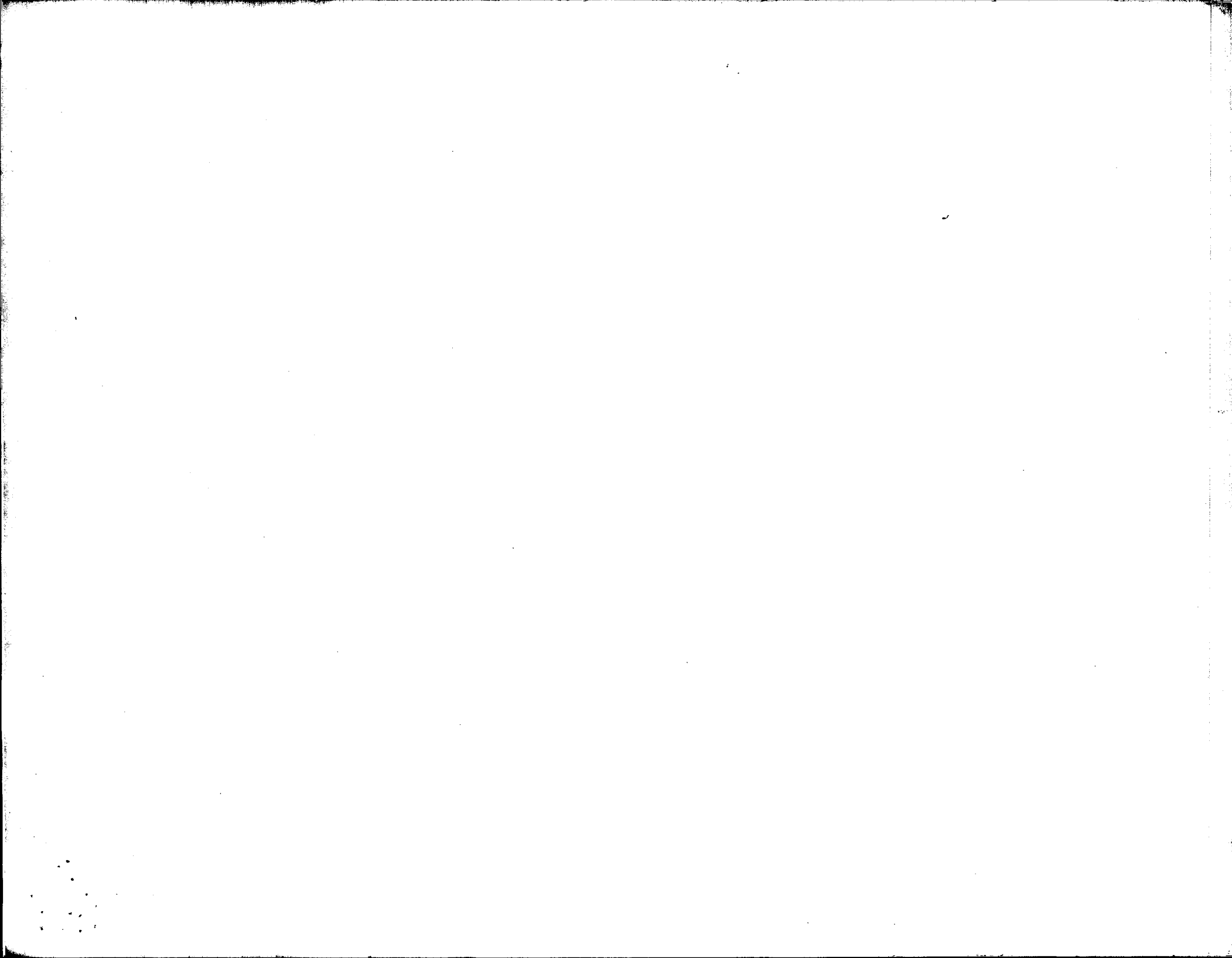
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
240									
Packaging	Memo	0.00			DAS				
Packaging	Identify and pack for shipping as per PPP D350-748-101				06				
	Location: _____				9-89				
	PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

MAR 18 2014

14-03-19

ME
14-3-18



Picklist Print

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Page 1

Work Order ID: 110173
Parent Item: D350-748-101
Parent Item Name: Fwd Crosstube

Start Date: 12/17/13 Required Date: 12/17/13
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-07-05 JLM
IPP Rev:B Update qty of MS21042L5 06-09-12 KJ VERIFY BY:DD
IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F 10.08.04 added QSI010
4.3 DD verf:EC
IPP REV:G ADD UNDER BEND COMMENT 12-05-28 JLM IPP REV:H 12.11.05 as per dwg
D350-748-141G DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-41A Bolt		Purchased	No			220	Each	674.0000	8	8	68-6 32 Sdg		

DAS
31
9-89

Location	Loc Qty	Loc Code
ST359	1	
123346	1	
ST515	2	
121185	2	
ST517	671	
124241	171	
124805	315	
124836	185	

M124241

AN4-6A BOLT	Purchased	No				220	Each	1,235.0000	16	16	68-6 32 Sdg		
----------------	-----------	----	--	--	--	-----	------	------------	----	----	-------------------	--	--

DAS
31
9-89

Location	Loc Qty	Loc Code
ST355	282	
123355	30	
M126175	2	
M127410	250	
ST514	953	
M126317	953	

M126317

12/3/18

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Page 2

Work Order ID: 110173
 Parent Item: D350-748-101
 Parent Item Name: Fwd Crosstube

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

AN532A
 Bolt

Purchased No

220

Each

267.0000

4 1 4

DAS
 32
 9-89

DAS
 31
 9-89

Location

Loc Qty

Loc Code

st503

267

124215

218

124805

5

m127363

14

m127550

30

M124215

D3500-1
 Saddle

Manufactured No

220

Each

97.0000

4 1 4

DAS
 32
 9-89

DAS
 31
 9-89

Location

Loc Qty

Loc Code

ST428A

12

95810

12

ST430A

66

108799

40

91888

8

94620

18

ST431

19

95381

19

9462024

9538126

D3501-1
 Bushing

Manufactured No

220

Each

485.0000

16 16

DAS
 32
 9-89

DAS
 31
 9-89

Location

Loc Qty

Loc Code

ST043

160

86913

160

ST051

2

103038

2

ST052

323

104369

80

105395

90

105576

40

88532

1

95165

112

105396

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Shop Packet Print

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Picklist Print

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Work Order ID: 110173
 Parent Item: D350-748-101
 Parent Item Name: Fwd Crosstube

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

220

Each

4,214.0000

24

24

DAS
32
9-89

DAS
06
9-89

Locknut

Location

Loc Qty

Loc Code

FP001	38
122452	38
GA	30
m126333	30
ST314	9
m125708	9
st507	33
m126073	33
ST509	2008
m126275	114
<u>m127255</u>	1894
ST510a	85
m126333	85
ST518	2011
124231	154
m127376	1857

m127266

DAS
06
9-89

MS21042L5

Purchased

No

220

Each

840.0000

4

4

DAS
32
9-89

11/13/17

Nut

Location

Loc Qty

Loc Code

GA	5
117611	5
ST314	335
125535	335
ST509	500
<u>m127304</u>	500

m127304

DAS
06
9-89

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Work Order ID: 110173
 Parent Item: D350-748-101
 Parent Item Name: Fwd Crosstube

Start Date: 12/17/13
 Start Qty: 1.00

Required Date: 12/17/13
 Required Qty: 1.00

NAS1149D0463J
 WASHER

Purchased No

220

Each

5,122.0000

32

32

m/127813 84
 68-6 05 3-8
 DAS

DAS
 31
 9-89

Location

Loc Qty

Loc Code

ST294	143
119097	1
121912	24
124198	35
124778	83
ST510a	4979
M126221	22
M127693	4957

m/126221 24b
 DAS
 32
 9-89

NAS1149D0563J
 Washer

Purchased No

220

Each

4,123.0000

8

8

DAS
 31
 9-89

Location

Loc Qty

Loc Code

GA	35
m125807	35
ST294	145
122452	91
123248	42
123355	12
ST510a	3943
m126319	3943

m/126319
 1 1 *JW 14-02-03*

D350-748-141TRN
 Crosstube Turning Detail

Manufactured No

110

Each

5.0000

Location

Loc Qty

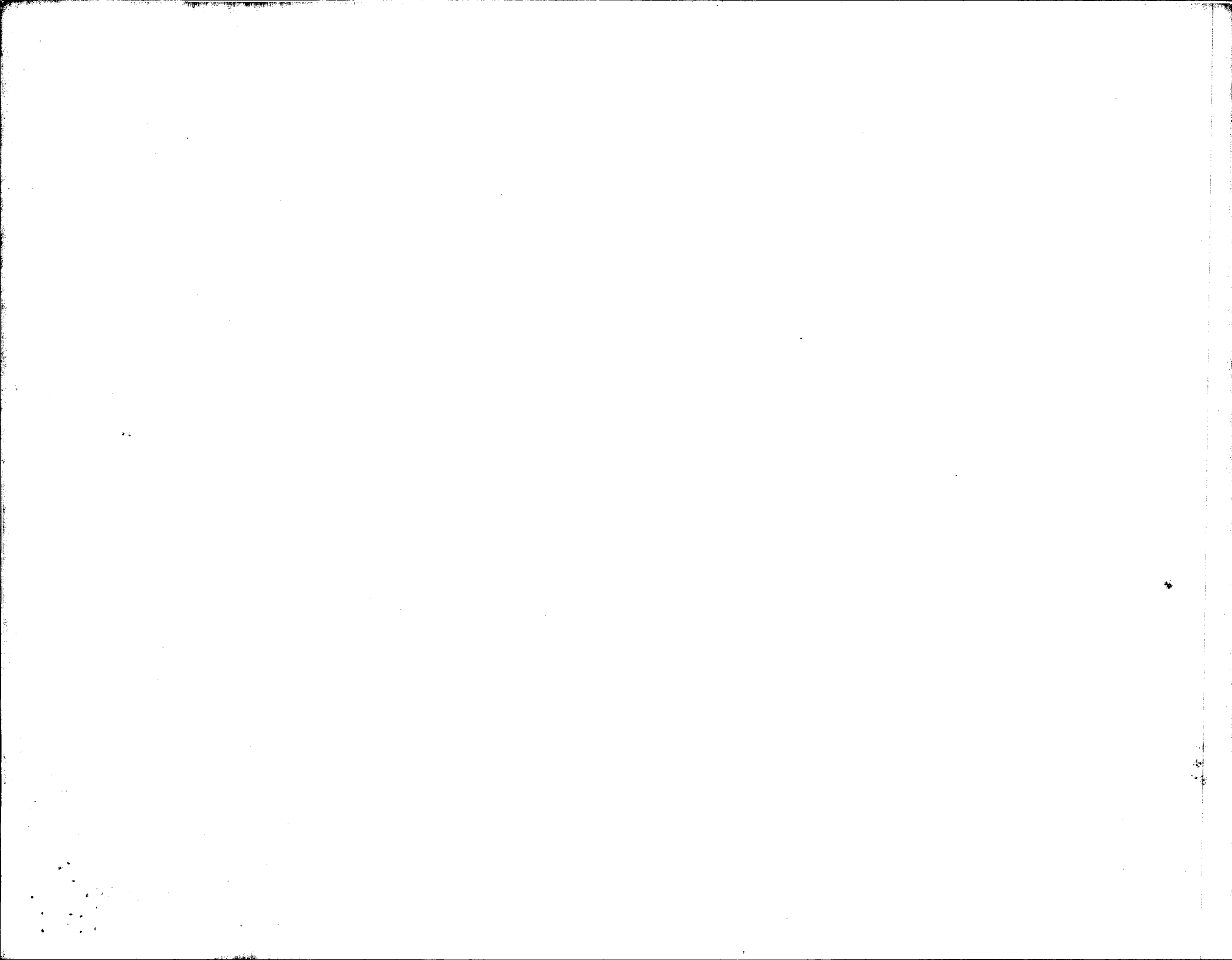
Loc Code

LG014	5
103232	1
84656	1
84658	1
84661	1
84665	1

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Parent Item: D350-748-101
Parent Item Name: Fwd Crosstube

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D3502-1
Support

Manufactured No

200

Each

79.0000

2

2

CR 14-03-15

Location

Loc Qty

Loc Code

LG050

79

104334

6

73419

3

74873

1

86876

1

88465

24

94722

20

97212

12

99764

12

2

D3595-063-395
Rubber Cushion

Manufactured No

200

Each

130.0000

2

2

CR 14-03-15

Location

Loc Qty

Loc Code

FG

5

87353

5

LG051

125

100373

7

102441

6

102890

3

105542

14

108010

36

109481

20

87353

17

94602

1

97526

17

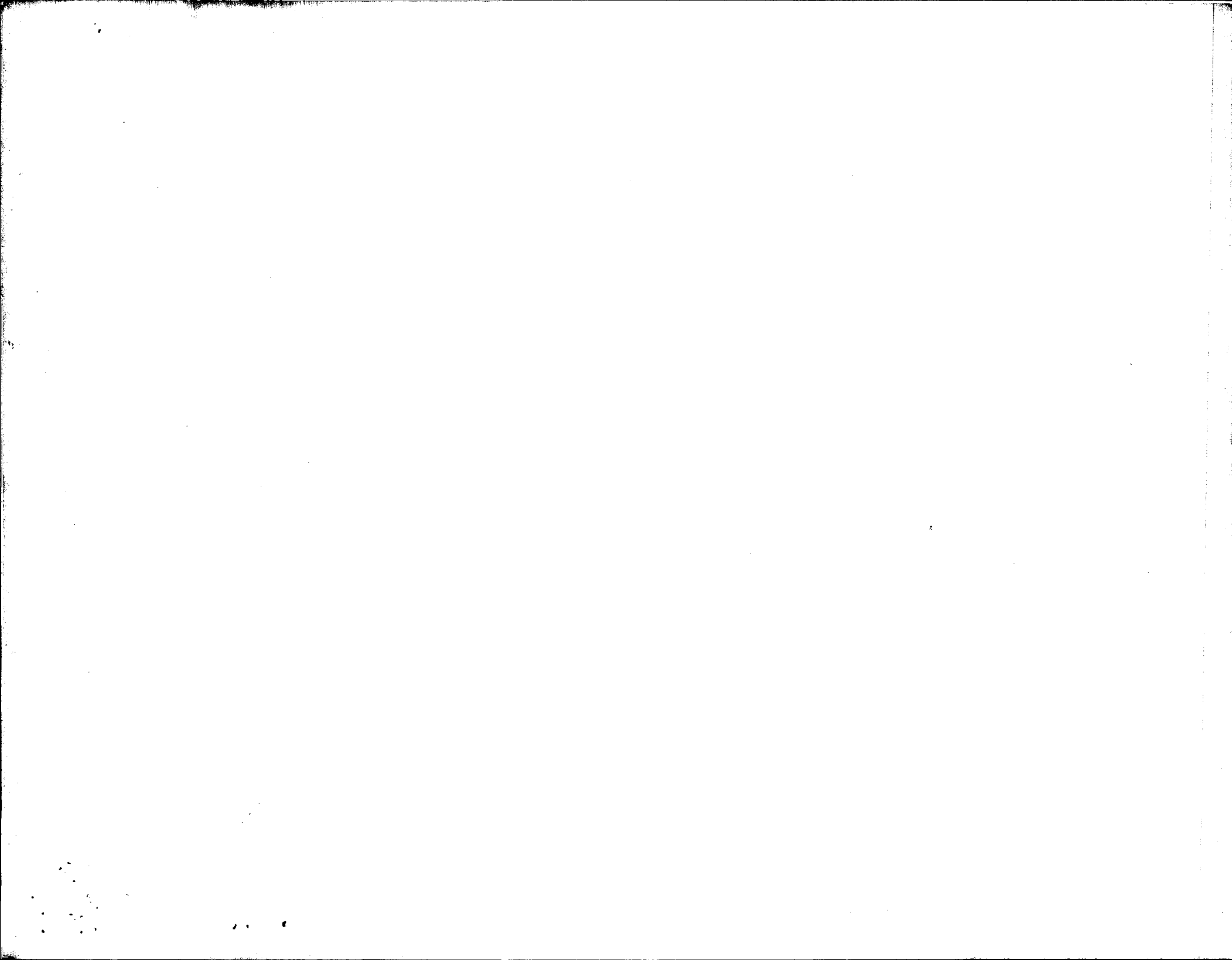
98361

4

1

1

110958



Picklist Print

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Work Order ID: 110173
Parent Item: D350-748-101
Parent Item Name: Fwd Crosstube

Start Date: 12/17/13 Required Date: 12/17/13
Start Qty: 1.00 Required Qty: 1.00

ALS4-1032-225
Rivnut

Purchased No

200

Each 848.0000

1 1

AP 14-3-14

Location

Loc Qty

Loc Code

128179
FG 30
M127028 30
ST280 129
M125954 20
M127028 109
st555 689
M127092 689

NAS1149D0363J
Washer

Purchased No

200

Each 4,179.0000

1 1

AP 14-3-14

Location

Loc Qty

Loc Code

GA 89
124392 89
ST294 11
113068 11
ST510a 4079
m126319 4079

MS21920-22
Clamp

Purchased No

200

Each 103.0000

2 2

CR 14-3-15

Location

Loc Qty

Loc Code

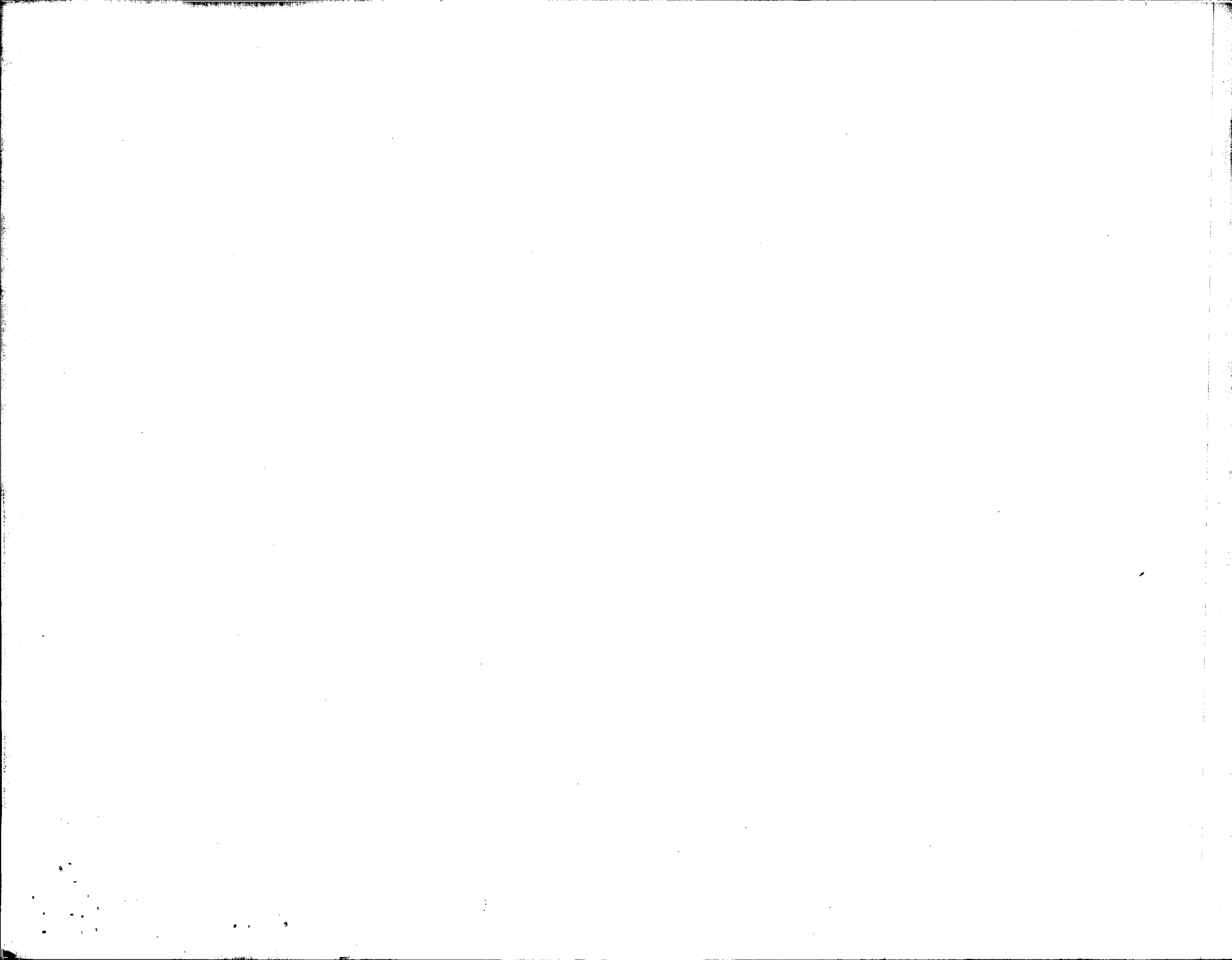
LG050 103
125487 5
M126420 4
M126637 4
M127255 40
M127608 50

2

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Picklist Print

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Work Order ID: 110173
Parent Item: D350-748-101
Parent Item Name: Fwd Crosstube

Start Date: 12/17/13 Required Date: 12/17/13
Start Qty: 1.00 Required Qty: 1.00

MS27039-1-10
SCREW

Purchased

No

200

Each

382.0000

1

1

127993

AS 14-3-14

Location

Loc Qty

Loc Code

GA	100
120449	100
ST305	26
122815	1
123522	18
125654	7
ST506	256
124326	10
m126474	246

①

December-17-13 9:17:28 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

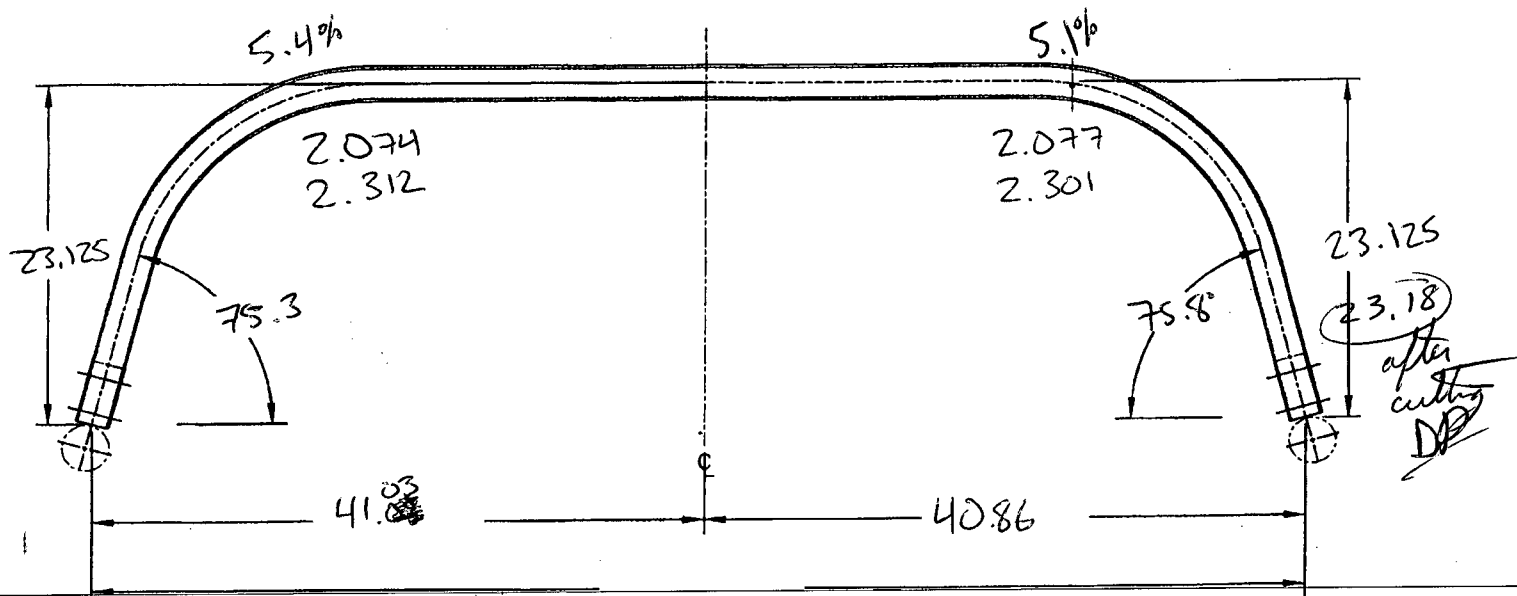
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

DART AEROSPACE LTD	Work Order: 110 173
Description: Crosstube High Fwd (AS350/355)	Part Number: D350-748-101
Inspection Dwg: D350-748-141 Rev: G	Page 1 of 1

Required Dimension	Min	Max
Height	23.12	23.38
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.55	82.05
Bending Passes	7	--
Crushing	--	6%
Twist	--	0.25



	Side A	Side B
Bending Passes	38	35
Crushing	5.4%	5.1%
Comments		
Twist 0.029 0.029		

QC15 Inspection	DP
Date	14-2-13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing & twist dimensions	KJ	
E	13.02.27	Dwg Rev updated	KJ	

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D3595-063-395	RUBBER CUSHION
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-22 OR MS 21920-21	CLAMP (PER DART SPEC. M-MS21920-21/22)
8	1	MS27039-1-10	SCREW
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH AFTER TURNING = 112.270 ± 0.06 (AFTER BENDING/TRIMMING = 110.27 REF)
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER 'D350-748-141' AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE. EXCEPT FOR Ø0.297 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS2759/1E AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.

BENDING

- 12) ALL DIMENSIONS FOR BENT TUBE ARE POST STRESS RELIEF
- 13) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 7% ON BOTTOM HALF OF BEND.
- 14) MAX AMPLITUDE OF RIPPING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- 15) AFTER BENDING, STRESS RELIEVE TUBE AT 650°F $\pm 0.25^\circ\text{F}$ FOR A MINIMUM OF 2 HRS AND ALLOW TO COOL TO AMBIENT TEMPERATURE (REF AMS2759/1E).
- 16) MAX TWIST AFTER STRESS RELIEF: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- 17) TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 18) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

110173 MJS
13-12-18

RELEASED
2012-11-01
MJS

G	RMV ABRASION STRIP, SUPPORT NOW W/ PROSEAL & CUSHION, ADD STRESS RELIEF, LONGER CUFF, NOW TRIMD AFTER BEND, ADD WALL DIMS & UPDATE TOL.	CP	12.09.12
F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES: UPDATE TO CURRENT ADD STANDARDS: RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.09.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G
D350-748-141 SHEET 1 OF 4
TITLE SCALE
CROSSTUBE (AS 350/355 HI FWD) NTS

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8 7 6 5 4 3 2 1

D

C

B

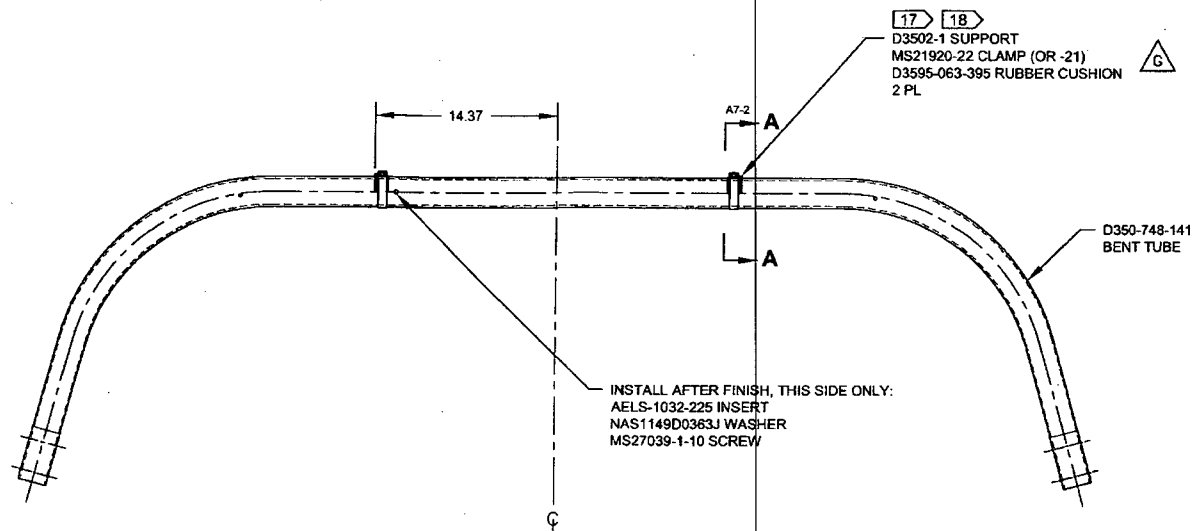
A

D

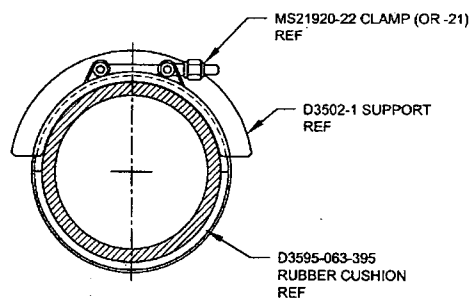
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B

A



**D350-748-141
ASSEMBLY DETAIL**

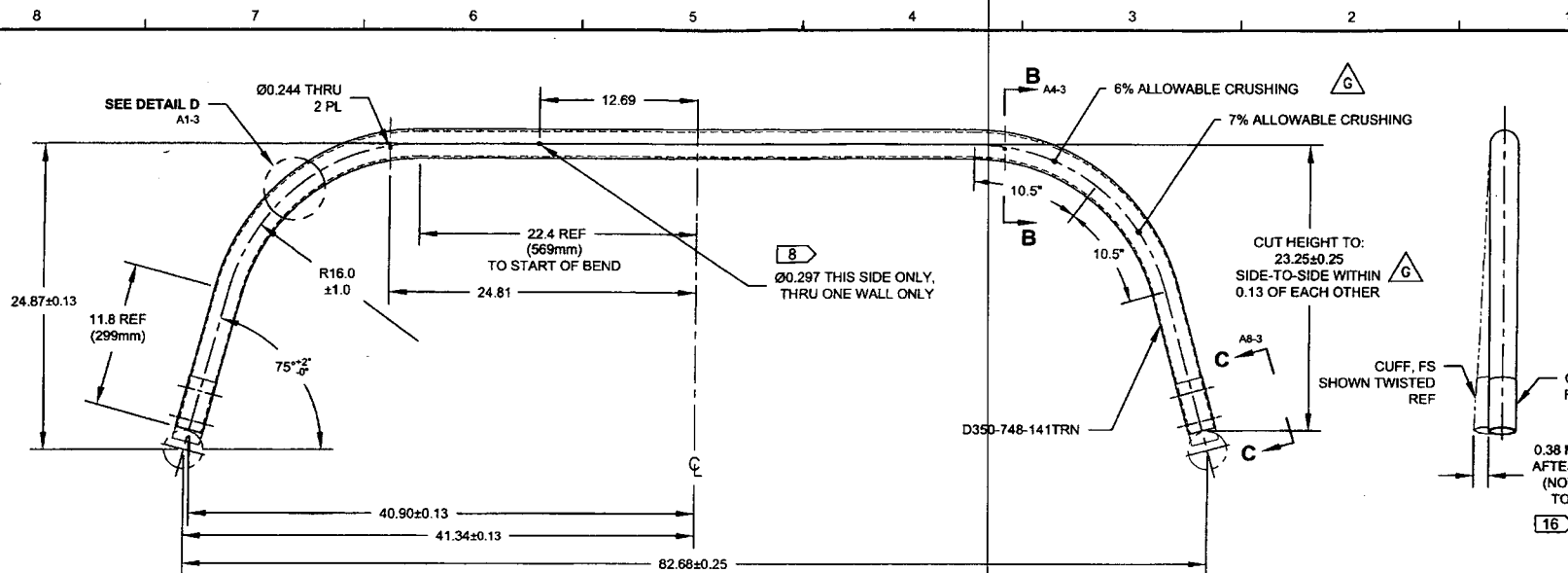


SECTION A-A D4-2
SCALE 6X

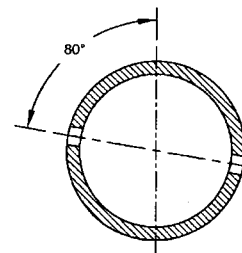
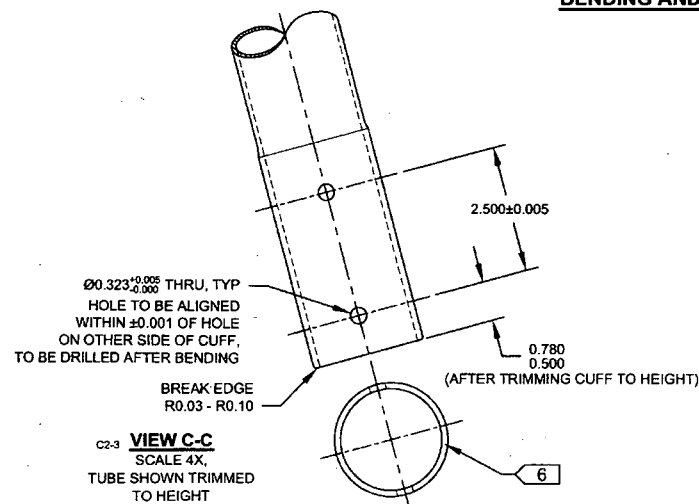
RELEASED
2012-11-01
WMP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D350-748-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	12.09.12	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

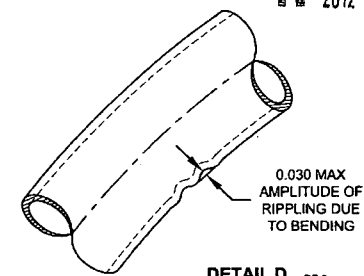
8 7 6 5 4 3 2 1



D350-748-141
BENDING AND DRILLING DETAIL 13



SECTION B-B
SCALE 6X



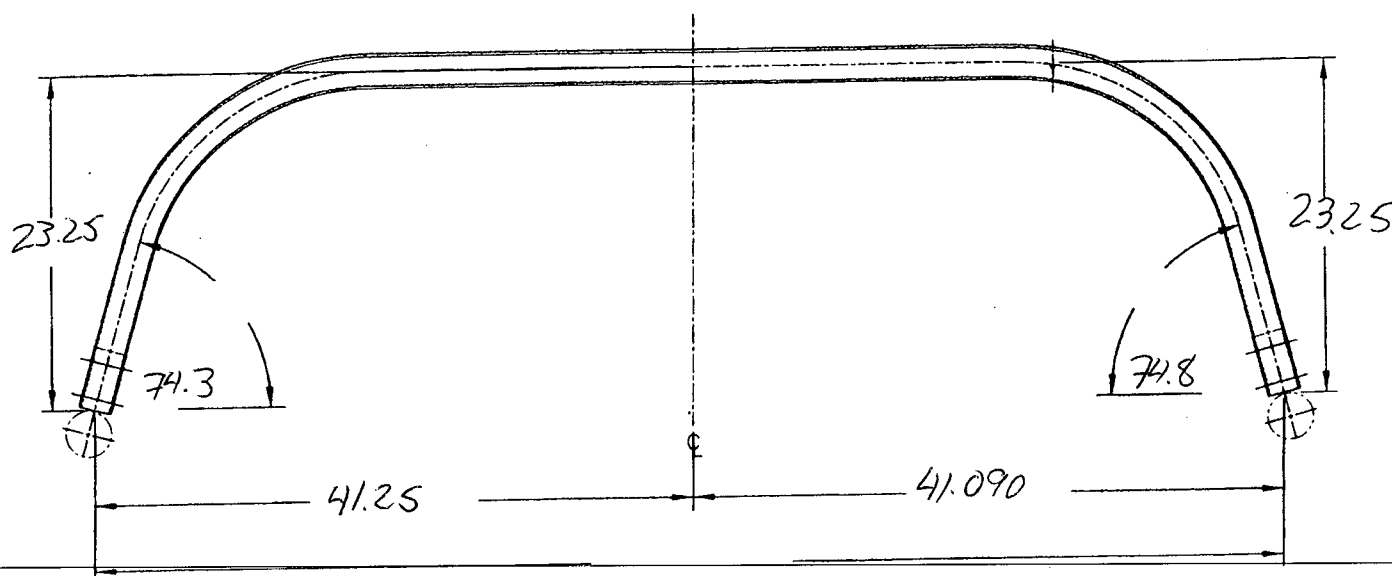
DETAIL D
SCALE 4X
RIPPING EXAGGERATED

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN	<i>g</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>W.D.</i>	D350-748-141	SHEET 3 OF 4
APPROVED	<i>W.D.</i>	TITLE	SCALE
DE APPR.	<i>W.D.</i>	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	12.09.12	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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RELEASED
2012-11-01

DART AEROSPACE LTD	Work Order: 110173
Description: Crosstube High Fwd (AS350/355)	Part Number: D350-748-101
Inspection Dwg: D350-748-141 Rev: F	Page 1 of 1

Required Dimension	Min	Max
Height	23.12	23.38
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.55	82.05
Bending Passes	7	--
Crushing	--	6%
Twist	--	0.25



	Side A	Side B
Bending Passes	38	35
Crushing		
Comments		
twist: 0.00		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing & twist dimensions	KJ	

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
193026	1	78470

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
		Steel	2014/2/3	CLIENT
QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

4 IN

160,

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
NIL	1	

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 4

POIDS EXPÉDIÉ / Weight Shipped : 160,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 4

POIDS EXPÉDIÉ / Weight Shipped : 160,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2014/02/04



Metcor Inc. METCOR INC.

5601 Route 111, St-Eustache (Québec) J7R 5A8
Tél: 450-473-1884

5601 Route 111, St-Eustache (Québec) J7R 5A8
Télécopieur / Fax administration: 450-491-5498
Télécopieur / Fax production: 450-491-6454

Tél: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Rapport d'Inspection

Inspection Report

BON DE TRAVAIL order	CHARGEMENT load
193026	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
		Steel		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

STRESS REL

SAE AMS 2759/1 REV.E

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

Visual

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
4	160	IN

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2014-02-04

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
193026	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
22878		Steel		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
STRESS REL				
SAE AMS 2759/1 REV.E				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
Visual				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
4	160	IN D350-748-201 CROSSTUBE 111460 102808 110174 110173		

COMMENTAIRES / comments

STRESS RELIEF 343C, 2 HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec AMS2759.

Le TT a été fait tel que requis par AMS2759 et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec AMS2759 et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of AMS2759.

All HT operations were in compliance with AMS2759 and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with AMS2759 and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

Isabel Otero
QA-Technician



DATE: 2014-02-05

Packing Slip



Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

S69983

Sold To:

Dart Aerospace Ltd.
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	DateReceived:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
PO23080	Mar-03-2014	NET 30 DAYS	10071 6547 RT0001		Mar-07-2014

Item #	Qty	P/N & Description	
1	1 EA	CROSSTUBE	S/N 110173
		P/N d350-748-101	W/O 133200
2	1 EA	CROSSTUBE	S/N 110174
		P/N d350-748-101	W/O 133201
3	1 EA	CROSSTUBE	S/N 102808
		P/N D350-748-201	W/O 133202
4	1 EA	CROSSTUBE	S/N 110707
		P/N D350-748-201	W/O 133203
5	1 EA	CROSSTUBE	S/N 111460
		P/N D350-748-201	W/O 133204
6	1 EA	CROSSTUBE	S/N 110110
		P/N D350-748-201	W/O 133205
7	1 EA	CROSSTUBE	S/N 110105
		P/N D350-748-201	W/O 133206
8	1 EA	CROSSTUBE	S/N 106692
		P/N D350-748-201	W/O 133207

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Mar-07-2014

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 133200
INVOICE #: 69983

**CONTRACT OR
PURCHASE ORDER #** PO23080

DESCRIPTION: CROSSTUBE

QTY 1

P/N # d350-748-101

S/N # 110173

STRIP IAW MIL-STD-871. MPI IAW ASTM-E-1444. CADMIUM PLATING
IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 1. FINAL MPI IAW
ASTM-E-1444. BAKE HEAT CHART # 14-189 AND # 14-204.

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**



Approved Inspector:

A handwritten signature in black ink, appearing to be 'R', written over a horizontal line.

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20196	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23335
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 14 CROSSTUBES:**

ID#: D350-748-201 AFT CROSSTUBE - HIGH

- 1 - WORK ORDER ID#: 102808
- 2 - WORK ORDER ID#: 110105
- 3 - WORK ORDER ID#: 110110
- 4 - WORK ORDER ID#: 111460
- 5 - WORK ORDER ID#: 110707

ID#: D212-664-201 AFT CROSSTUBE - HIGH

- 6 - WORK ORDER ID#: 114476
- 7 - WORK ORDER ID#: 114477
- 8 - WORK ORDER ID#: 114478
- 9 - WORK ORDER ID#: 114479

ID#: D350-748-101 FWD CROSSTUBE

- 10 - WORK ORDER ID#: 110174
- 11 - WORK ORDER ID#: 110173

ID#: D407-667-105 FWD CROSSTUBE

- 12 - WORK ORDER ID#: 114428
- 13 - WORK ORDER ID#: 112868
- 14 - WORK ORDER ID#: 112869

Action Taken:	Date:	Initial/Stamp:				
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-14) AS PER ASTM1417M-13 NO CRACK FOUND Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018	DOT-APP 177 53-89 12-MARCH 2014	DOT-APP 177 53-89 [Signature]				
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: ANTONINO Marchetta	DOT-APP 177 53-89	12-MARCH 2014

Work Order ID 110173

December-17-13 9:17:28 AM

110173

Page 1

Item ID: D350-748-101

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Crosstube

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-141	G								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG003

MLJ 14-03-17

105

QC15- Crosstube Dimensional Check

0.00

105

QC

Memo

0.00

Quality Control

VERIFY WITH VENDER FOR OVEN TIME AVAILABILITY

N/A
JW